

Date: Thursday, 3/8/2007 3:40:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 31146		
Estimate Number	: 10531		
P.O. Number	: N/A	Part Number	: D2572
This Issue	: 3/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30593	Drawing Revision	: E
		Material	: N/A
		Due Date	: 3/30/2007
Written By	: <u>HA 07.03.08</u>	Qty:	10 Um: Each
Checked & Approved By	: <u>HA 07.03.08</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #

Machine Or Operation:

Description:

1.0

D6101005

7075-T7351 8.25X5.0X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No:

R25352

En

07/04/21 (10)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 31146 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove shap edges.

SD/En 07/04/27

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

SD/En 07/04/27

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



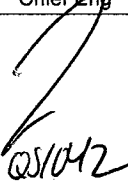

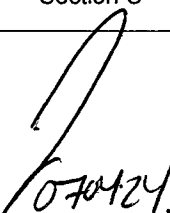


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/En 07/04/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.04.24	2.0	-1 part scrap. 'Y' origin was off by .500". Root Cause: origin was taken wrong. previous machinist.	 QS/04/2	Scrap & replace, the part is already destroyed.	 07.04.24	 07.04.24	 QS/04/2	 07.04.24

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31146

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/04/27

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h

07/04/30

(10X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103 706

ysd

07-05-01 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/5/02

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/5/02

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/02

Job Completion



W 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31146
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.745	1.750	1.751		
C	3.495	3.505		3.498	3.500	3.501	3.500		
D	1.745	1.755		1.748	1.749	1.748	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		0.494	0.501	0.494	0.494		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.492	0.492	0.495		
J	1.174	1.184		1.176	1.178	1.177	1.177		
K	0.558	0.578		0.564	0.562	0.563	0.567		
L	1.174	1.184		1.176	1.178	1.178	1.179		
M	1.490	1.500		1.494	1.493	1.496	1.497		
N	2.495	2.505		2.490	2.497	2.498	2.501		
O	3.869	3.879		3.870	3.871	3.870	3.871		
P	0.115	0.135		0.124	0.122	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.126	0.125	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.233	0.237	0.233		
W	0.115	0.135		0.132	0.132	0.132	0.133		
X	0.307	0.312		0.311	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.364	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.240	0.24	0.252		
AE	1.375	1.395		1.385	1.382	1.384	1.384		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.248	0.248	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN S D
Date:	07/04/23

Audited by:	J.F.
Date:	07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31146
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.440	.440	.440	0.440		
B	1.745	1.755		1.748	1.748	1.749	1.748		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.748		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.494	.495	0.500	0.496		
G	0.257	0.262	DT8683	.260	.260	0.260	0.266		
H	0.375	0.380	DT8684	.376	.376	0.377	0.377		
I	0.490	0.510		.496	.496	0.504	0.503		
J	1.174	1.184		1.176	1.176	1.178	1.175		
K	0.558	0.578		.564	.564	0.566	0.565		
L	1.174	1.184		1.176	1.176	1.178	1.175		
M	1.490	1.500		1.494	1.494	1.495	1.495		
N	2.495	2.505		2.499	2.499	2.500	2.499		
O	3.869	3.879		3.870	3.870	3.872	3.872		
P	0.115	0.135		.124	.125	0.123	0.123		
Q	0.115	0.135		.125	.125	0.135	0.135		
R	0.240	0.260		.252	.252	0.253	0.254		
S	0.115	0.135		.125	.125	0.125	0.124		
T	0.178	0.198		.188	.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.239	0.236	0.237		
W	0.115	0.135		.132	.132	0.126	0.121		
X	0.307	0.312		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.762	0.765	0.765		
Z	0.352	0.372		.365	.365	0.364	0.364		
AA	0.470	0.530		.500	.500	0.520	0.520		
AB	0.615	0.635		.627	.627	0.627	0.627		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.246	.246	0.249	0.250		
AE	1.375	1.395		1.385	1.385	1.386	1.385		
AF	0.115	0.135		.135	.135	0.135	0.135		
AG	0.240	0.280		.260	.260	0.260	0.260		
AH	0.240	0.260		.246	.246	0.251	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.032	.032	0.023	0.033		

Accept/Reject

Measured by:	EN / M8P
Date:	07/04/25

Audited by:	J.F.
Date:	07/04/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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B	1.745	1.755		1.749	1.748				
C	3.495	3.505		3.498	3.499				
D	1.745	1.755		1.749	1.748				
E	7.990	8.010		8.001	8.002				
F	0.490	0.510		0.497	0.494				
G	0.257	0.262	DT8683	0.260	0.260				
H	0.375	0.380	DT8684	0.377	0.377	0	0		
I	0.490	0.510		0.502	0.500				
J	1.174	1.184		1.178	1.177				
K	0.558	0.578		0.564	0.563				
L	1.174	1.184		1.178	1.177				
M	1.490	1.500		1.494	1.492				
N	2.495	2.505		2.499	2.496				
O	3.869	3.879		3.872	3.871				
P	0.115	0.135		0.123	0.123				
Q	0.115	0.135		0.135	0.135		0		
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.125	0.127				
T	0.178	0.198		0.188	0.188		0		
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.235	0.235				
W	0.115	0.135		0.129	0.126				
X	0.307	0.312		0.311	0.311				
Y	0.760	0.765		0.765	0.765		0		
Z	0.352	0.372		0.365	0.362				
AA	0.470	0.530		0.500	0.500	0	0		
AB	0.615	0.635		0.628	0.625				
AC	0.053	0.073		0.063	0.063	0	0		
AD	0.240	0.260		0.247	0.248				
AE	1.375	1.395		1.385	1.386				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.260	0.260		0		
AH	0.240	0.260		0.250	0.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									





Measured by:	EP
Date:	07/04/27

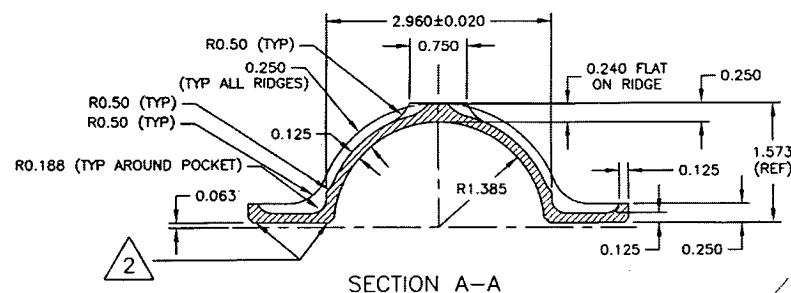
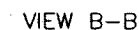
Audited by:	J.F.
Date:	07/04/27

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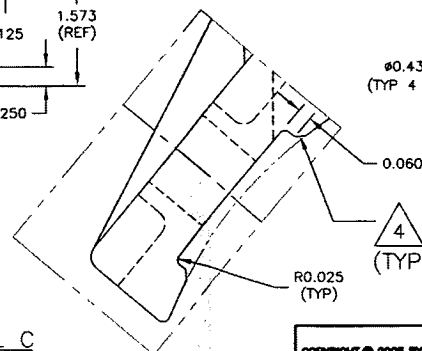
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



	ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
	CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
	CHAMFER 0.063 x 45° ALL AROUND
	CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY DS PH	 DART AEROSPACE LTD. <small>HARRISBURY, ONTARIO, CANADA</small>
CHECKED 	APPROVED 	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE
		REV. SHEET 1 OF 2 SCALE

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WORK ORDER
NO. 31146